

MUST SHIP WED 29/11

Dart Aerospace Ltd.

Date: Thursday, 11/23/2006 1:09:51 PM
User: Kim Johnston

OR SOONER

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP WELDMENT RH (FOLDING)	
Job Number	: 29685			Part Number	: D2801042	
Estimate Number	: 11653			Drawing Number	: D2801 REV A 1	
P.O. Number	: N/A			Project Number	: N/A	
This Issue	: 11/23/2006 S.O. No. : N/A			Drawing Revision	: A 1	
Prsht Rev.	: NC			Material	: N/A	
First Issue	: N/A			Due Date	: 11/29/2006	
Previous Run	: 27848			Qty:	2 Um: Each	
Written By	: <u>J. 06/11/23</u>					
Checked & Approved By	: <u>J. 06/11/23</u>					
Comment	: Est B01.04.26 Changed D2802-042 to -2 EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Qty Part # Description Batch: 1 D2622-120C Extrusion <u>B28215</u>	
		Check Material for any Dents or Defects	
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1 1-Cut D2622 extrusion to 86.15" long as per Dwg D2801 2-Deburr and bevel ends for welding	
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	
4.0	D2734	206 Step Endplate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2734 End Cap <u>B27281</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 1:09:52 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT RH (FOLDING)

Job Number: 29685

Part Number: D2801042

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D28022 Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2802-2 Arm 329688=1
325709=3



PL. 06-11-24

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld arms as per Dwg D2801

PL. 06-11-24

2-Weld one end cap as per Dwg D2801

PL. 06-11-24

3-Grind end cap welds flush

PL. 06-11-24

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PL. 06-11-27 (2)

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PL. 06-11-27 (2)

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AM 06/11/27 (2)

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PL. 06-11-27 (2)

11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last end cap as per dwg D2801

PL. 06-11-27 (2)

2-Grind welds flush

PL. 06-11-28 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 1:09:52 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT RH (FOLDING)

Job Number: 29685

Part Number: D2801042

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M 06/11/28 (2)

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M 06/11/28 (2)

14.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch-up alodine

a.m

06/11/28

(2)

15.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06/11/28

(2)

16.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06/11/28 (2)

17.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2801 and QSI 005 4.4

M 102635 a.m 06/11/29 (2)

18.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FC 06/11/29 (2)

19.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Rev A1 LB 06/11/29

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/11/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/29 (1)

Job Completion



u 06.11.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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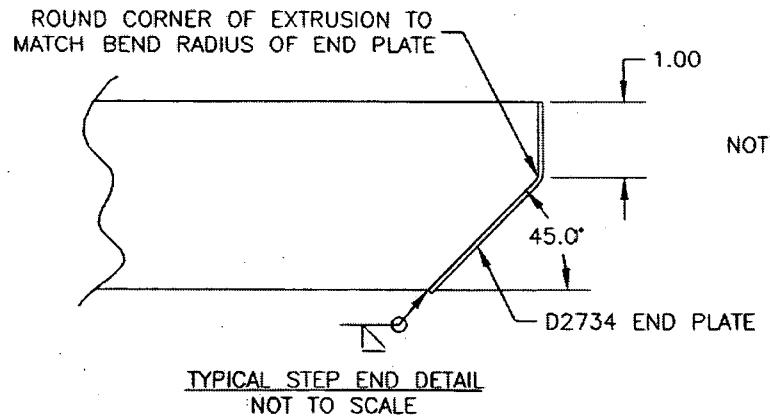
NOTE: Date & initial all entries



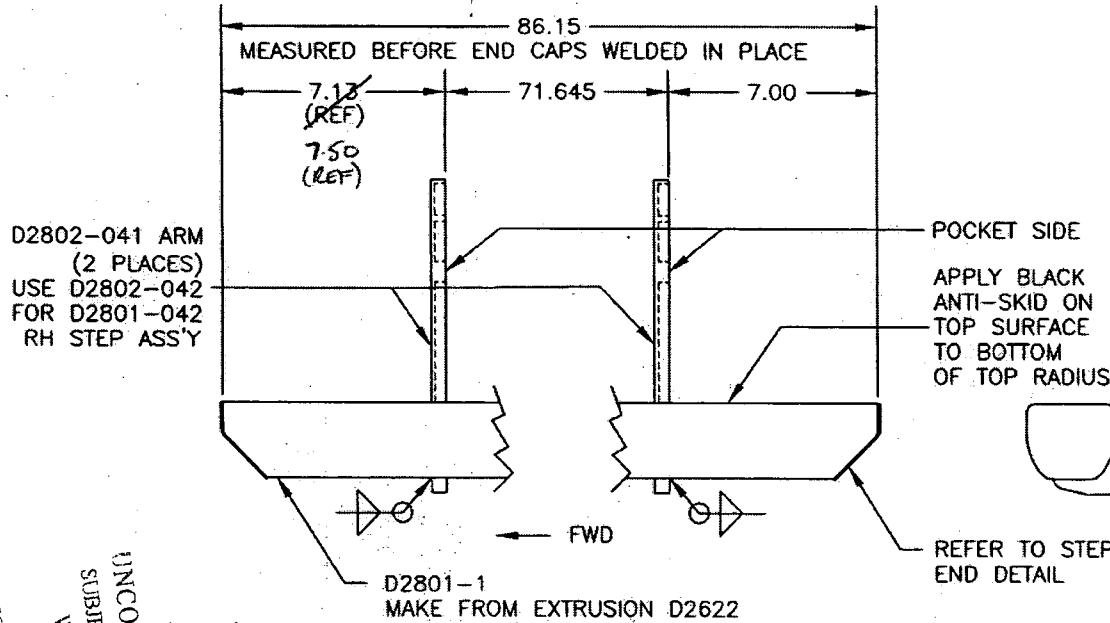
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DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
<i>CP</i>	<i>HP</i>	D2801	
DATE	TIME	STEP WELDMENT	SCALE
00.11.03	00.11.03	NEW ISSUE	NIS
A	03.08.15	7.50 mts 7.13	
A1			

RELEASED
00.11.13 *CP*



TYPICAL STEP END DETAIL
NOT TO SCALE



D2801-041 LH STEP ASSEMBLY (SHOWN)
D2801-042 RH STEP ASSEMBLY (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *29685*